

NON-EXTRACTED

Work Order ID 51897

September 9, 2009 10:41:57 AM

Page 1

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09 Start Qty: 5.00

Required Date: 9/18/09 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002...



8/2/02/22

HJ for BG 09/09/21

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod m111311
m111494

3-Grind End Plate flush

1/2 09.09.10

5

Work Order ID 51897

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Page 2

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09 Start Qty: 5.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start

Work Order ID 51897

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Page 3

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09 Start Qty: 5.00

Required Date: 9/18/09 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

M. H 09/09/14

(50)

QC

Memo

0.00

Quality Control

160

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Assemble Leg Assembly as per Dwg D3272.

SE 09.09.14

5X

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

⇒ S 09/09/15

(x50)

Work Order ID 51897

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Page 4

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09 Start Qty: 5.00

Required Date: 9/18/09 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & DwgD3272

A/RAluminum Rod

4-Grind End Plate flush

5-Install last rivet.

190

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

09.09.15

5

5 BE 09/09/15

Work Order ID 51897

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Page 5

Item ID: D350-591-312

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Start Date: 9/10/09 Start Qty: 5.00

Required Date: 9/18/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:45pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 1:15pm



27 09/09/16

X5RH

mp 09/09/16

X5

22 09/09/16

X5RH

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Required Date: 9/18/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

Wing Walk as per dwg QSI005 4.4 Batch *m112106* 0.00



HandFinish

Memo

0.00

MO 0910917

X5

Hand Finishing

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BK 09-09-17

(5)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

9/9/21 @ Sp

Packaging

Work Order ID 51897

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Page 7

Item ID: D350-591-312

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Required Date: 9/18/09 Req'd Qty: 5.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: D

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W

✱

Close at C4G002
Non-Eurocopter

✱

149/9/225

09/09/24 HJ

MF

09-09-24

(52K) p

Picklist Print

September 9, 2009 10:41:40 AM

Page 1

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 9/10/09

Required Date: 9/18/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSI 9410-011 		Manufactured	No				Each	0.0000	5.0000			
Step Modification												
D3067-1RevA 		Manufactured	No			110	Each	25.0000	5.0000			
End Plate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

51104

25

D3272-1RevB

Manufactured

No

110

Each

0.0000

5.0000

Step

MS21042L5 - K2

Purchased

No

110

Each

1,331.000

10.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1331

110382

10

111636

321

112314

1000

51933

SP

09-09-10

5+5

351180 09-09-09

111636

9/9/21 BSp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:40 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09

Required Date: 9/18/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No			160	Each	32.0000	5.0000			
Step Leg Assembly Hi												

09-09-14 *[Signature]*

Warehouse Loc Qty Loc Code

[Handwritten mark]

Location

Main Warehouse

ST

20

51125

20

Main Warehouse

WA

12

50095

12

10

D3066-1RevB Manufactured No

160 Each 0.0000 10.0000



[Handwritten mark]

350383

09-09-14 (10)

Spacer

D3219-1RevA Manufactured No

160 Each 61.0000 10.0000



09-09-10

Plate

Warehouse Loc Qty Loc Code

[Handwritten mark]

Location

Main Warehouse

ST

61

47296

17

51186

44

09-09-10

7
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:41 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH


Comments:

Start Date: 9/10/09

Required Date: 9/18/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	2,679.000	80.0000			
												
Rivets												

CR9163-4-04

3 M103947



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2679

110731

215

111359

46

111477

74

112082

-56

112314

2000

112385

400

AN3-35A

x2

Purchased

No

260

Each

541.0000

10.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

541

106993

12

110467

29

112314

500

112314 9/9/21 525

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:41 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/10/09

Required Date: 9/18/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No			260	Each	917.0000	40.0000			



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	917
107321	1
107534	5
107959	23
109285	37
110552	66
110865	3
111477	15
111925	7
112314	760
17406	0
51764	0

112314 9-9-21 508

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:42 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/10/09

Required Date: 9/18/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-36A *+2* Purchased

No

260

Each

595.0000

10.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

595

109545

11

110467

7

110731

4

112243

23

112314

500

112385

50

112314 50

AN960JD10 *+4*

Purchased

No

260

Each

2,309.000

20.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2309

105442

95

109059

2

109840

23

110985

202

111279

13

111668

70

112314

1000

112369

904

112369 9-9-21 (50) S

September 9, 2009 10:41:42 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:42 AM

Work Order ID: 51897



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09

Required Date: 9/18/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			260	Each	8,730.000	80.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8730	
102929	2	
105906	4	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	101	
111916	2606	
112314	4887	
16941	0	

111916 9/9/21 @ SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:43 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/10/09

Required Date: 9/18/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			260	Each	1,202.000	20.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1202
100564	2
106167	6
107534	34
107959	43
108246	46
108672	2
109059	49
109752	22
110363	46
110523	57
111279	43
112082	352
112314	500

D2230-3RevG

Manufactured No

260

Each

0.0000

20.0000



Lug



51187
50306
51568

9/9/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:44 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09

Required Date: 9/18/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2618RevB1		Manufactured	No			260	Each	371.0000	10.0000			



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST039 20

50659 20

Main Warehouse

ST39 351

50989 200

51189 151

D2856-400RevA - x2 @ 72" Manufactured No



Abraison Strip

260 f 332.4577 3.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 122.8077

42437 44.93

46543 77.8777

Main Warehouse

ST403 209.65

50593 209.65

5189 90

50593 9-9-21 5054

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 9, 2009 10:41:51 AM

Work Order ID: 51897

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Comments:

Start Date: 9/10/09

Required Date: 9/18/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA		Manufactured	No			260	Each	25.0000	5.0000			
												
End Plate												

Handwritten: 09-09-15

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 25

51104 25

D3235-1RevA *Handwritten: R2*

Manufactured No

260 Each 213.0000 10.0000



Mounting Lug

5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 213

45398 4

46745 109

47969 100

46745 9-9-09 *Handwritten: SV*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

September 9, 2009 10:41:51 AM

Work Order ID: 51897



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/10/09

Required Date: 9/18/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC		Manufactured	No			260	Each	60.0000	5.0000			



Support Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 20

47886 20

Main Warehouse

ST471 40

51191 40

51191 sl

MS21042L3

Purchased

No

260

Each

3,778.000

10.0000



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3778

110844 32

111274 254

111668 992

112314 2000

112385 500

11274 9-9-21 (Sx) SC

Picklist Print

September 9, 2009 10:41:57 AM

Work Order ID: 51897

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Comments:

Start Date: 9/10/09

Required Date: 9/18/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			260	Each	8,288.000	40.0000			



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8288	
107499	5	
110450	1	
110507	254	
111827	5996	
112314	1991	
15924	0	
8182	41	

112314

9-9-21 (S) SP

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H**W/O 51897*△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

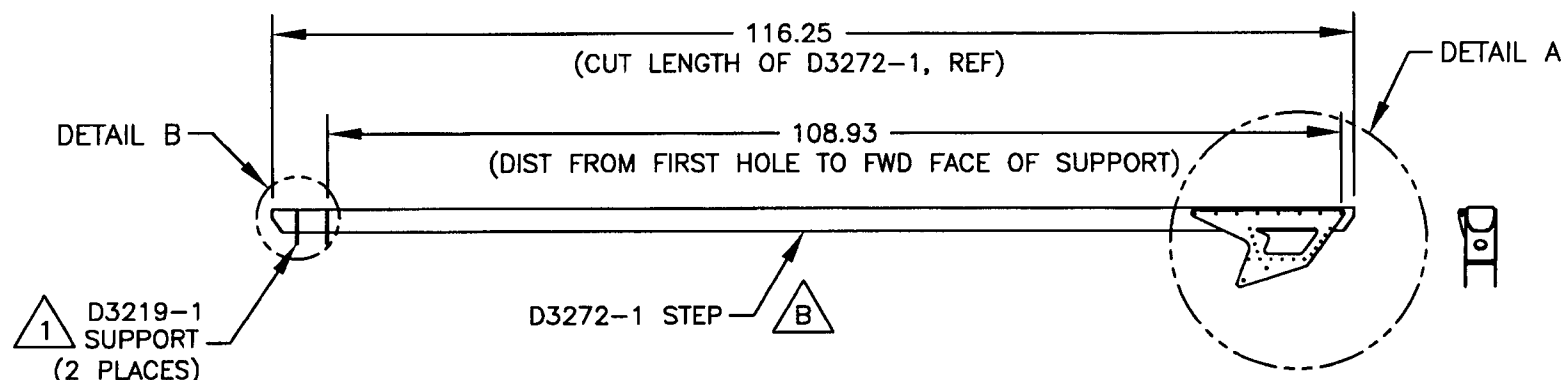
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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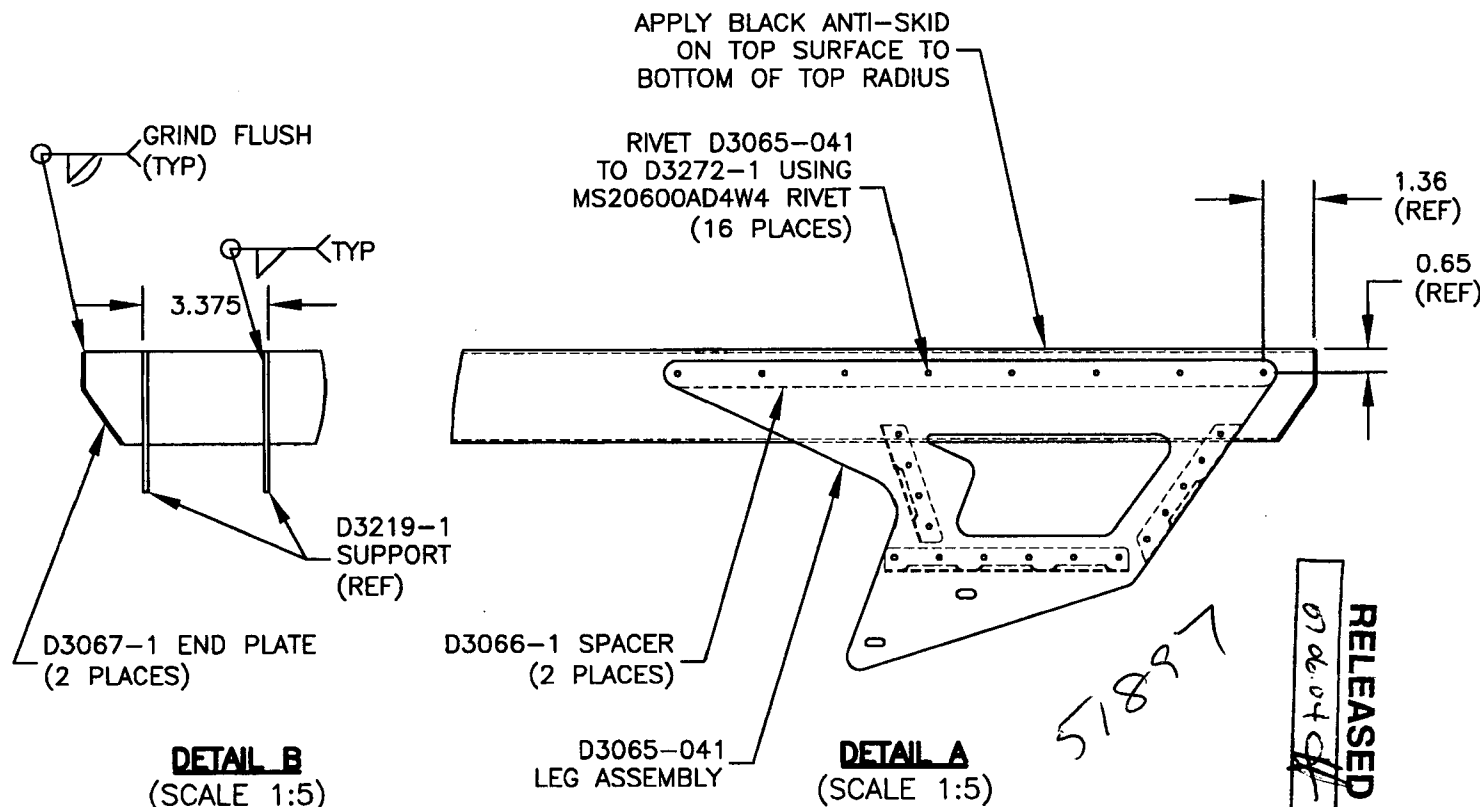
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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	TITLE	SCALE	
07.05.18	STEP ASSEMBLY, HI LONG	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

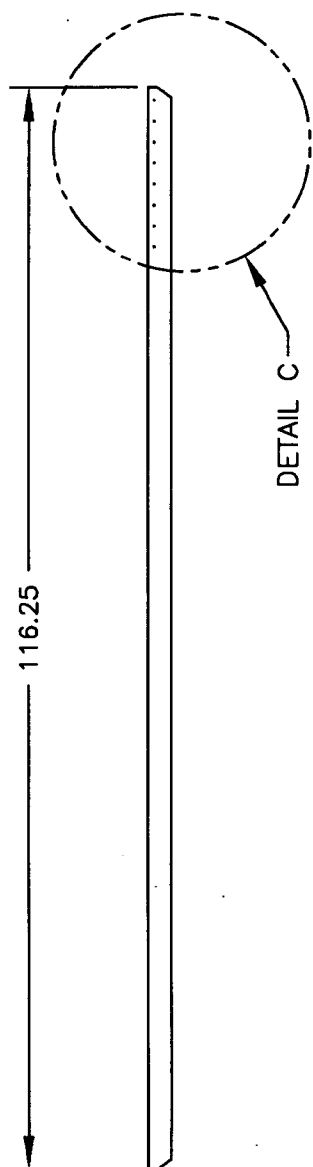




DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 QF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

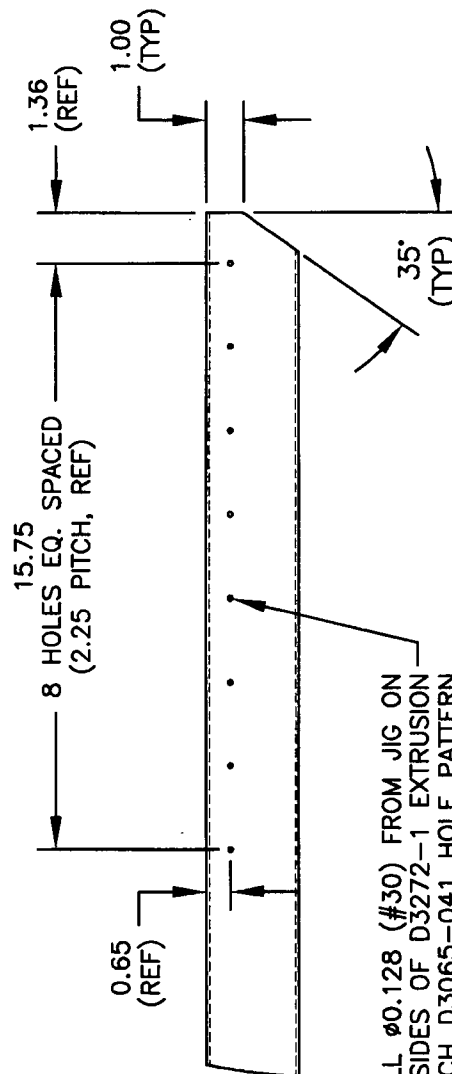
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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51896

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

51897

REFERENCE ONLY